

Work Order ID 126335

126335

Page 1

Tuesday, November 04, 2014 1:57:14 PM

Item ID: D4154-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 11/4/2014 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/4/2014 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 11-11-05 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4154	E

100		0.00							DAS 23 9-89
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100

Waterjet

FLOW CNC Waterjet

304.050"

Memo

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: IE

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
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110

QC

Quality Control

Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Doc/Data									
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126335

Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
150									
Packaging	Memo	0.00				810	14-12-01		MAL
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							14/12/2 J
Quality Control									

(N)
14-12-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, November 04, 2014 1:57:17 PM

Page 1

Work Order ID: 126335

126335

Parent Item: D4154-1

D4154-1

Parent Item Name: Plate

Start Date: 11/4/2014

Required Date: 11/4/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

419.6684

4.2697

~~36~~

32

DAS

23

9-89

14-11-24

M304S18GA

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

409.6684

117188

3

117766

5

120604

5

122325

3

123155

3

124572

35.73

M126647

31.55

M128254

34.746

M128435

35.45

M128864

12.6982

M129530

111.6185

M130345

128.8757

MAT020

10

M126098

10

130923

130923

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	126335
Description: Plate		Part Number:	D4154-1
Inspection Dwg: D4154	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	0.402"	-		✓	Jkm01
0.450	+/-0.010	0.451"	-		✓	
0.125	+/-0.010	0.123"	-		✓	
0.38	+/-0.030	0.376"	-		✓	
0.88	+/-0.030	0.88"	-		✓	
1.19	+/-0.030	1.19"	-		✓	
5.273	+/-0.010	5.273"	-		✓	
6.42	+/-0.030	6.42"	-		✓	
5.223	+/-0.010	5.223"	-		✓	
6.72	+/-0.030	6.725"	-		✓	
40.76	+/-0.030	40.76"	-		T	Jkm03
15.45	+/-0.030	15.45"	-		T	
66.51	+/-0.030	66.51"	-		T	
70.45	+/-0.030	70.45"	-		T	
90.41	+/-0.030	90.41"	-		T	
91.56	+/-0.030	91.56"	-		T	
0.050	+/-0.010	0.047"	-		✓	
Ø0.516	+0.008/-0.001	0.516"	-		✓	

Measured by:	DAS 23 9-89	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	14-11-24	Date:	NOV 25 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	
D	12.07.31	Dwg Rev updated	KJ	
E	12.09.26	Dimensions updated per Dwg Rev E	KJ	

1911

1912

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

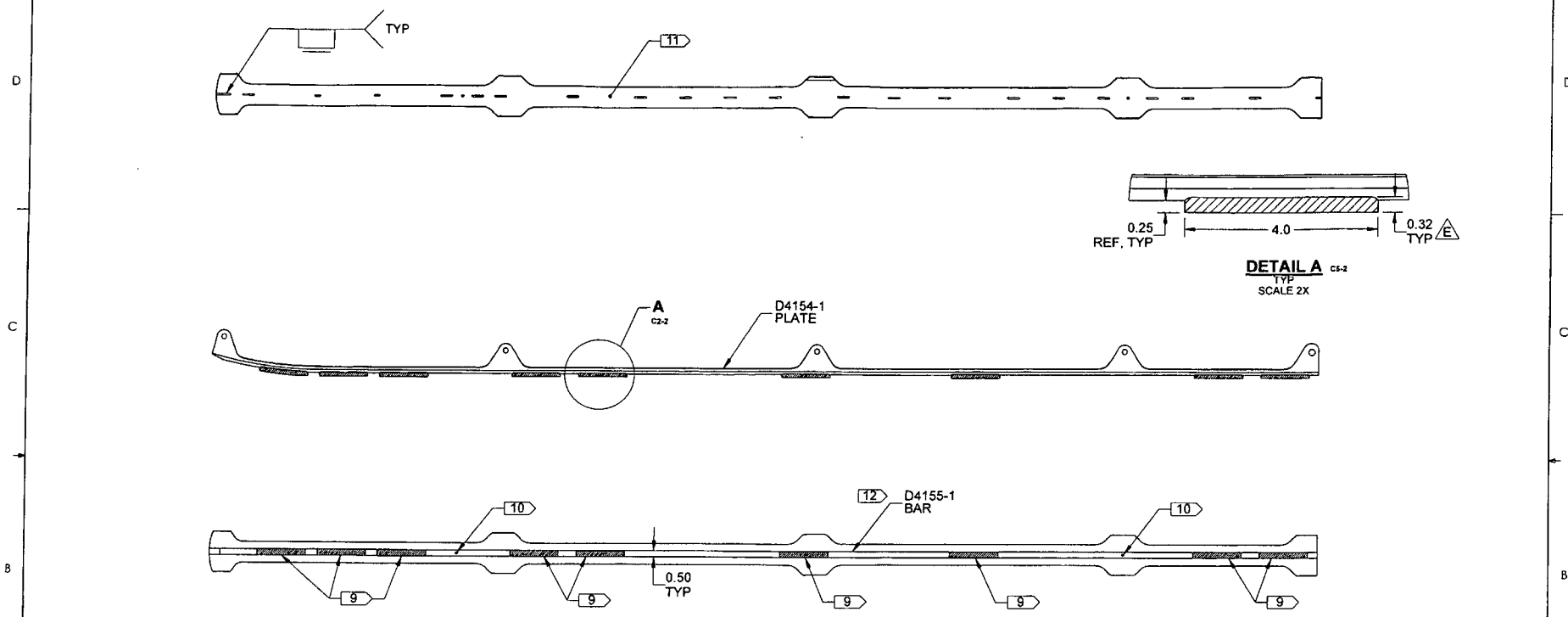
NO 126335 MJS
14-11-05

RELEASED
R 2012-09-04
WJ

D4154-041 WEARPLATE ASSEMBLY

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø 0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED	SP	DRAWING NO.	REV. E
MFG. APPR.	N	D4154	SHEET 1 OF 4
APPROVED	N	TITLE	SCALE
DE APPR.	N	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1







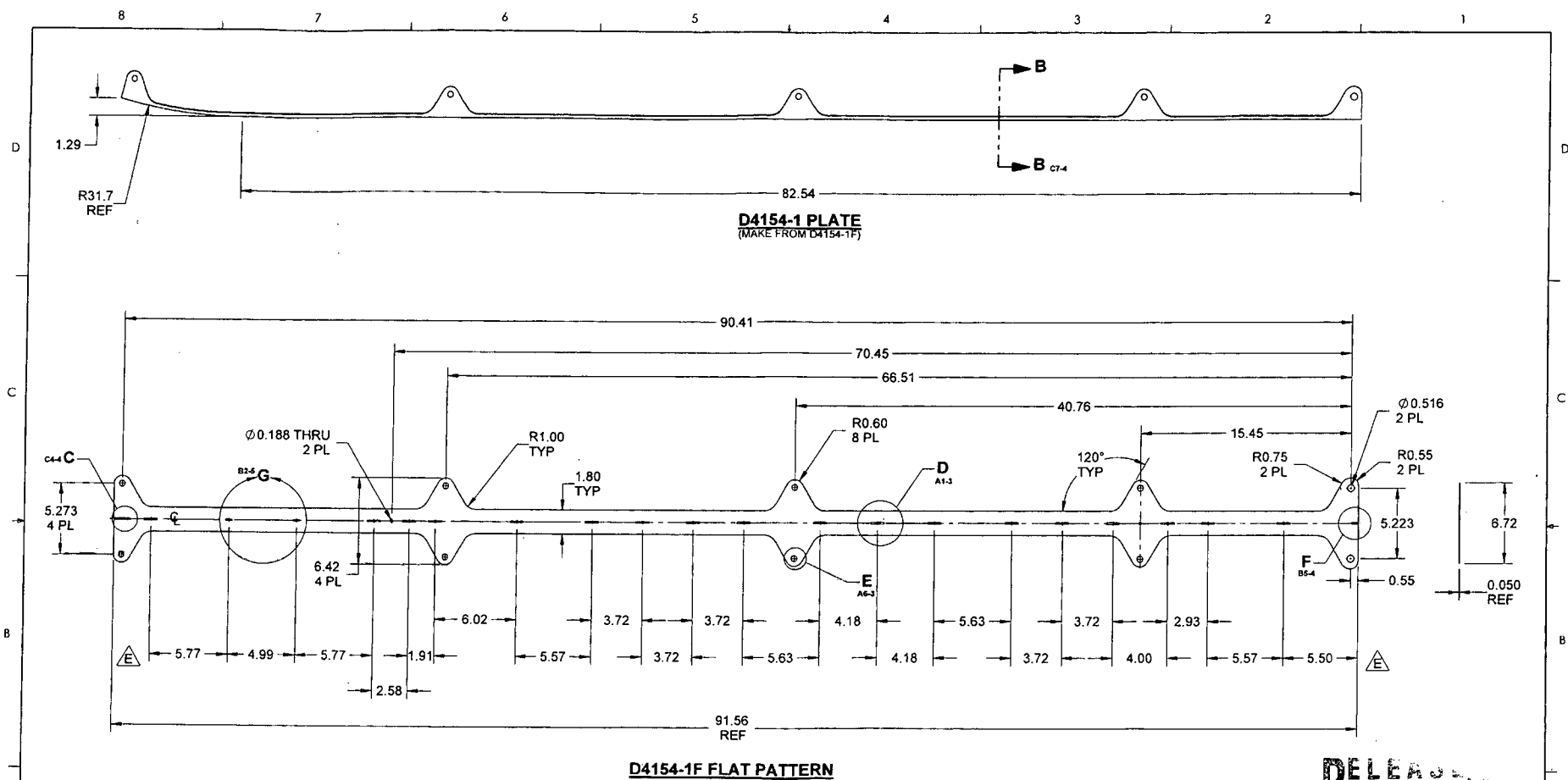
D4154-041 WEARPLATE ASSEMBLY

RELEASE
2012-09-04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.75 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL Δ
- 10) TRANSFER DRILL \varnothing 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4154	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

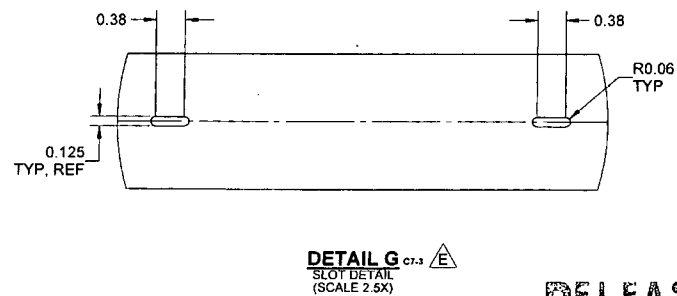
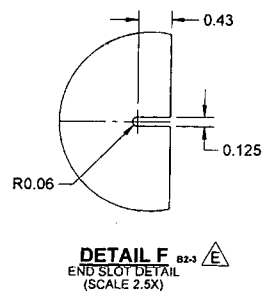
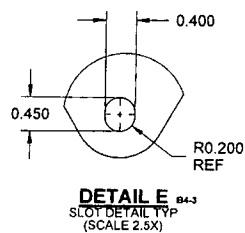
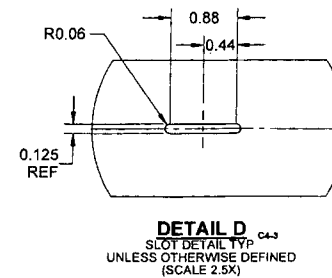
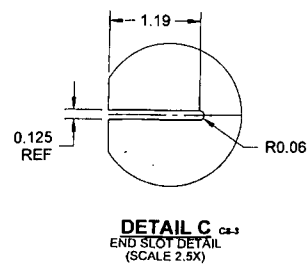
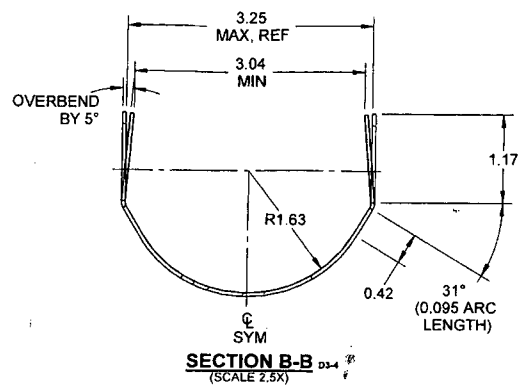


RELEASE
2012-09-04
MD

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
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